

Date: Friday, 7/4/2008 12:48:46 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 206/OH-58 SADDLE, INBOARD, LEFT SIDE
Job Number : 40283	
Estimate Number : 10836	
P.O. Number : 	Part Number : D29391
This Issue : 7/4/2008 S.O. No. :	Drawing Number : D2939 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : 1/1 Type : MACHINED PARTS	Drawing Revision : C
Previous Run : 36143	Material :
Written By : <u> </u>	Due Date : 7/30/2008 Qty: 10 Um: Each
Checked & Approved By : <u> </u>	
Comment : Est: B 00.06.26 New DWG rev (mpp 2069) EC	
Est Rev:C As per Rev C 07-03-19 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101001	Saddle Billet
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)
 Issue material from stock: 7075-T7351 QQ-A-250/12
 Cut Size 2.0 x 6.25 X 6.00
 Grain Along Long 6.00 Length
 Batch No: B 34201

J.F. 08/08/29 (10)

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 Program part number and batch number.
 1-Inspect part number and batch number are programmed correctly.
 2-Machine Step No 1 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet
 3-Machine Step No 2 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet
 4-Machine Step No 3 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet
 5-Deburr

J.F. 08/08/29 (10)

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE
 Machine Keyway and inspect per attached dimension sheet

J.F. 08/08/29 (10)

4.0	QC1	INSPECT ALL DIM TO DIM SHEET
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Comment: INSPECT ALL DIM TO DIM SHEET

J.F. 08/08/29 (10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 7/4/2008 12:48:46 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, INBOARD, LEFT SIDE

Job Number: 40283

Part Number: D29391

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

JS 08/08/02 (10)

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

FL 08/08/02 (10)

7.0

POWDER COATING

POWDER COATING



M 108523



(10K)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

10:40
320°F
11:10

M-L 08/09/02

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

FL 08/09/02 (10)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

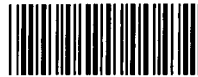
ST 8430

-1 RISS
JS 08/09/03

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/09/03

Job Completion



MF 08-09-03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	40283
Description: 206 Saddle, Inboard, Left side	Part Number:	D2939-1
Inspection Dwg: D2939 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2939 Rev. C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		.131	.127"	.127"	.128"		
B	0.100	0.140		.131"	.125"	.125"	.125"		
C	0.100	0.140		.119"	.128"	.120"	.119"		
D	0.210	0.230		.225"	.220"	.221"	.220"		
E	1.245	1.255		1.250"	1.250"	1.250"	1.250"		
F	1.245	1.255		1.250"	1.250"	1.250"	1.250"		
G	2.495	2.505		2.500"	2.500"	2.500"	2.500"		
H	0.510	0.515		.510"	.510"	.510"	.510"		
I	1.572	1.582		1.576"	1.576"	1.576"	1.576"		
J	2.495	2.505		2.503"	2.503"	2.503"	2.503"		
K	0.257	0.262		Ø.258"	Ø.258"	Ø.258"	Ø.258"		
L	0.312	0.317		Ø.313"	Ø.313"	Ø.313"	Ø.313"		
M	0.235	0.240		.237"	.236"	.237"	.237"		
N	0.100	0.140		.121"	.120"	.121"	.120"		
O	0.540	0.560		.549"	.550"	.549"	.549"		
P	0.490	0.510		.505"	.504"	.504"	.504"		
Q	3.715	3.725		3.722"	3.722"	3.722"	3.722"		
R	2.720	2.760		2.742"	2.742"	2.742"	2.742"		
S	0.240	0.270		.269"	.251"	.251"	.251"		
T	0.100	0.180		.140"	.140"	.140"	.140"		
U	1.625	1.635		1.632"	1.632"	1.632"	1.632"		
V	1.362	1.372		1.369"	1.369"	1.369"	1.369"		
W	0.316	0.321		Ø.320"	Ø.320"	Ø.320"	Ø.320"		
X	1.250	1.270		1.250"	1.259"	1.261"	1.259"		
Y	1.565	1.585	DT8695 A/B	1.565"	1.574"	1.576"	1.574"		
Z	0.178	0.198		R.188"	R.188"	R.188"	R.188"		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	J.F.
Date:	08/08/28

Audited by:	RF
Date:	08/08/28

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

DART AEROSPACE LTD	Work Order:	40283
Description: 206 Saddle, Inboard, Left side	Part Number:	D2939-1
Inspection Dwg: D2939 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2939 Rev. C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	15	16	17	18		
A	0.100	0.140		.128"	.125"	.125"	.124"		
B	0.100	0.140		.127"	.125"	.124"	.123"		
C	0.100	0.140		.121"	.122"	.121"	.121"		
D	0.210	0.230		.220"	.221"	.219"	.219"		
E	1.245	1.255		1.250"	1.250"	1.250"	1.250"		
F	1.245	1.255		1.250"	1.250"	1.250"	1.250"		
G	2.495	2.505		2.500"	2.500"	2.500"	2.500"		
H	0.510	0.515		.510"	.510"	.510"	.510"		
I	1.572	1.582		1.576"	1.576"	1.576"	1.576"		
J	2.495	2.505		2.503"	2.503"	2.503"	2.503"		
K	0.257	0.262		Ø .258"	Ø .258"	Ø .258"	Ø .258"		
L	0.312	0.317		Ø .313"	Ø .313"	Ø .313"	Ø .313"		
M	0.235	0.240		.236"	.236"	.236"	.236"		
N	0.100	0.140		.120"	.119"	.119"	.119"		
O	0.540	0.560		.550"	.550"	.550"	.549"		
P	0.490	0.510		.504"	.505"	.505"	.505"		
Q	3.715	3.725		3.722"	3.722"	3.722"	3.722"		
R	2.720	2.760		2.742"	2.742"	2.742"	2.742"		
S	0.240	0.270		.251"	.251"	.251"	.251"		
T	0.100	0.180		.140"	.140"	.140"	.140"		
U	1.625	1.635		1.632"	1.632"	1.632"	1.632"		
V	1.362	1.372		1.369"	1.369"	1.369"	1.369"		
W	0.316	0.321		Ø .320"	Ø .320"	Ø .320"	Ø .320"		
X	1.250	1.270		1.258"	1.258"	1.258"	1.259"		
Y	1.565	1.585	DT8695 A/B	1.573"	1.573"	1.573"	1.574"		
Z	0.178	0.198		R.188"	R.188"	R.188"	R.188"		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	J.F.
Date:	08/08/29

Audited by:	RF
Date:	08/08/29

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

DART AEROSPACE LTD	Work Order: 40283
Description: 206 Saddle, Inboard, Left side	Part Number: D2939-1
Inspection Dwg: D2939 Rev. C	Page 1 of 1

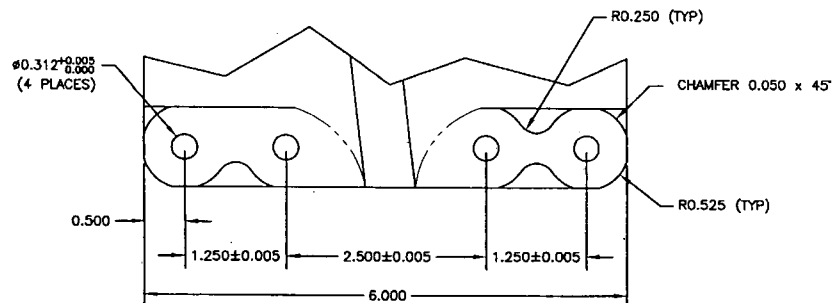
Inspect dimensions highlighted on inspection sheet drawing D2939 Rev. C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1 9	2 10	3	4		
A	0.100	0.140		.125"	.125"				
B	0.100	0.140		.124"	.123"				
C	0.100	0.140		.124"	.124"				
D	0.210	0.230		.220"	.219"				
E	1.245	1.255		1.250"	1.250"				
F	1.245	1.255		1.250"	1.250"				
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R	2.720	2.760		2.742"	2.742"				
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T	0.100	0.180		.140"	.140"				
U	1.625	1.635		1.632"	1.632"				
V	1.362	1.372		1.369"	1.369"				
W	0.316	0.321		Ø .320"	Ø .320"				
X	1.250	1.270		1.258"	1.259"				
Y	1.565	1.585	DT8695 A/B	1.578"	1.578"				
Z	0.178	0.198	1.573 ✓	B.188"	A.188"				
AA									
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AF									
AG									
AH									
Accept/Reject									

Measured by: J.F.
Date: 08/08/29

Audited by: <i>RF</i>
Date: 08/08/29

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	<i>[Signature]</i>

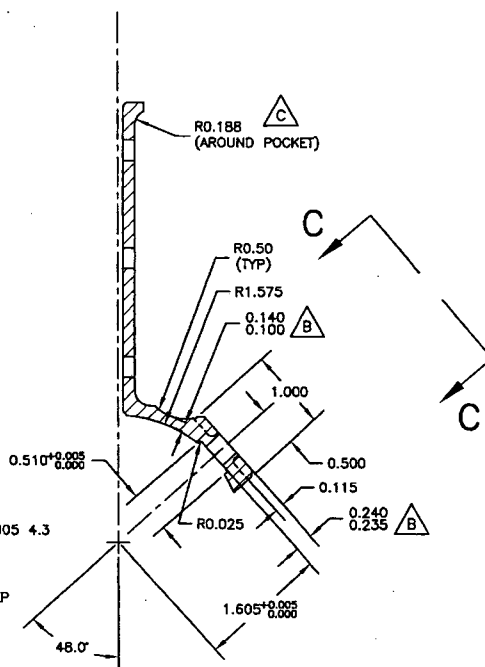


VIEW C-C

D2939-1 LH SADDLE (SHOWN)
D2939-2 RH SADDLE (OPPOSITE)

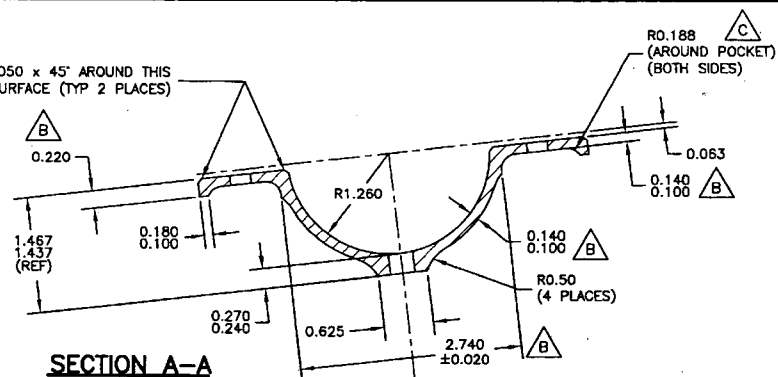
NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-001 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

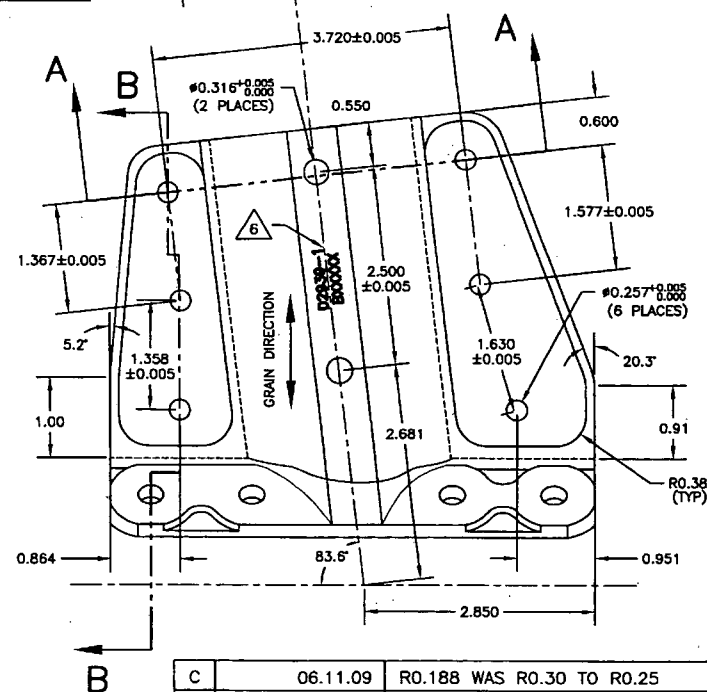


SECTION B-B

CHAMFER 0.050 x 45° AROUND THIS SURFACE (TYP 2 PLACES)



SECTION A-A



C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED DEOMETRY AND MATERIAL
A	99.11.12	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE USA, INC.
CHECKED	APPROVED	DRAWING NO. D2939
DATE	TITLE	SADDLE INSIDE
06.11.09		

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REV. C
SHEET 1 OF 1

SCALE

2:3

NO. 40283
WORK ORDER
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07.02.12